

Date: Monday, 2/25/2008 11:17:54 AM
 User: Kim Johnston

Process Sheet

14

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: D119 HELI UTILITY BASKET PRELIM
Job Number	: 37594		
Estimate Number	: 12452		
P.O. Number	:	Part Number	: D119756041
This Issue	: 2/25/2008 S.O. No. :	Drawing Number	: IIN PG11-12
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 37593	Material	:
Written By	:	Due Date	: 3/30/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>HA 08 02 26</u>		
Comment	: Est Rev. A New Issue 06-06-14 JLM		
	: Est Rev. B 06.07.26 dwg revB, picklist EC		
	: est rev C revC dwg 07.04.09 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0 DC

DOCUMENT CONTROL



000131

002



Comment: Photocopy bluefile & type labels per PPPD119-756-041

CHG-001

08 03 27

2.0 37594A

BASKET LID ASS'Y (A119)



Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT

ml 08/03/31

3.0 37594B

BASKET BASE ASS'Y (A119) PRELIMINARY



Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT

ml 08/03/31

4.0 D2022101

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: 33988

C

5.0 D2258220

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: 35979 30810

C

6.0 D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: 36549

A 4/3/31 (1)

pro

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D119-756-041 PAR #: N/A Fault Category: Prod. Issues NCR: Yes No DQA: JS Date: 08.03.31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/31	5	Had wrong label change for D 2258-220 RC: Employee did not read P/N correctly.	<i>JS</i>	removed label & scrap & put good label D 2258-220 B30810	<i>ml</i> 08/03/31	<i>JS</i> 08.03.31	<i>JS</i>	<i>JS</i>
				Estimate is correct				

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:17:54 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37594

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: 36659

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: 36397

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 36853

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: 21139

11.0

D35191

placard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

placard

Batch: 337692

12.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M106815

13.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 102190

Handwritten signature and date 8/3/3'0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37594

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: 104937

Handwritten signature

15.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: 104847

Handwritten signature

16.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: 107242

Handwritten signature

17.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: 106780

Handwritten signature

18.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: 106785

Handwritten signature

19.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: 106654

Handwritten signature

20.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: 106918

Handwritten signature

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37594

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M105442

22.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: 18071

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: 106883

24.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: 106825

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: 106825 106277

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D119-756

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

25.1 2x D3757-1 B 38068
25.2 6x AN310A B 17546 M14820
25.3 12x AN960 JD10 B B106552
25.4 6x MS21042L3 B 106883

per DSI9405 see attached U 08/03/18

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37594

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

29.0

D119756011

CLAMP KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CLAMP KIT

Batch: B37599

30.0

D26173

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

B 29991

31.0

D26175

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

35977

32.0

D351611

CLEVIS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CLEVIS

batch: B 37619

33.0

D35171

STRUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

STRUT

Batch: 31628 31802

34.0

D3518041

STRUT ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

FWD ARM ASSEMBLY

Batch: 37621

8/3/31 ①

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37594

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D35201

SPACER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SPACER 37623

36.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M106993

37.0

AN415A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
Batch: M106375

38.0

AN420A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M16895

39.0

AN510A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M107013

40.0

AN960JD416

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)
Washer
Batch: M106780

41.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer M106785

8/3/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37594

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

AN960JD516L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer M17619

43.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Nut
Batch: M106825

44.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D119
Location: _____
PPP Rev: C

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.03.31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

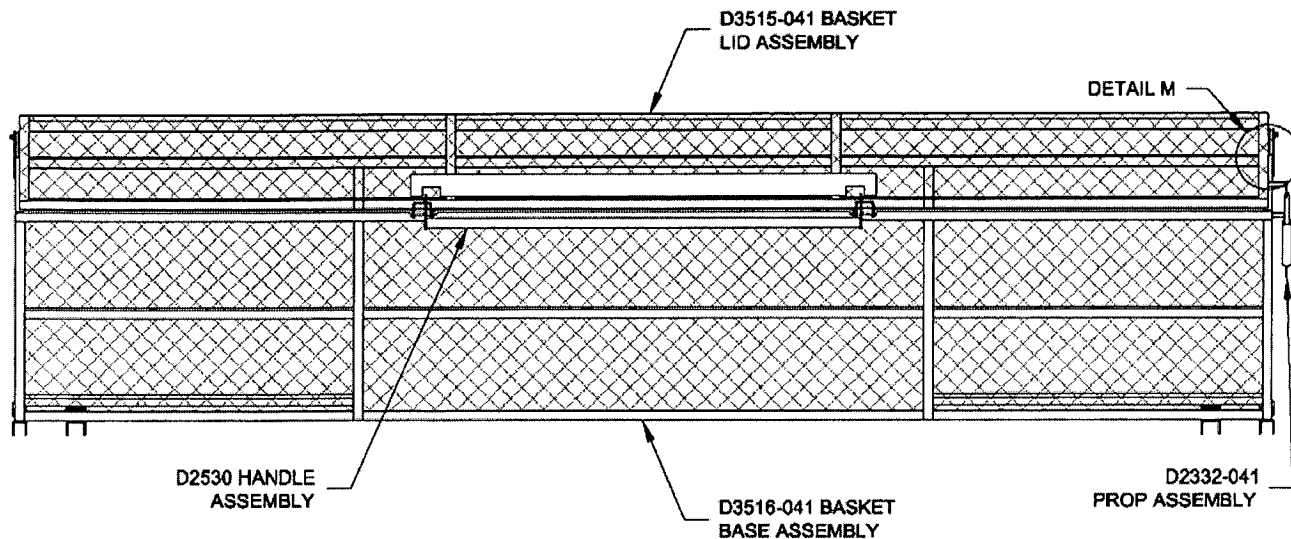
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

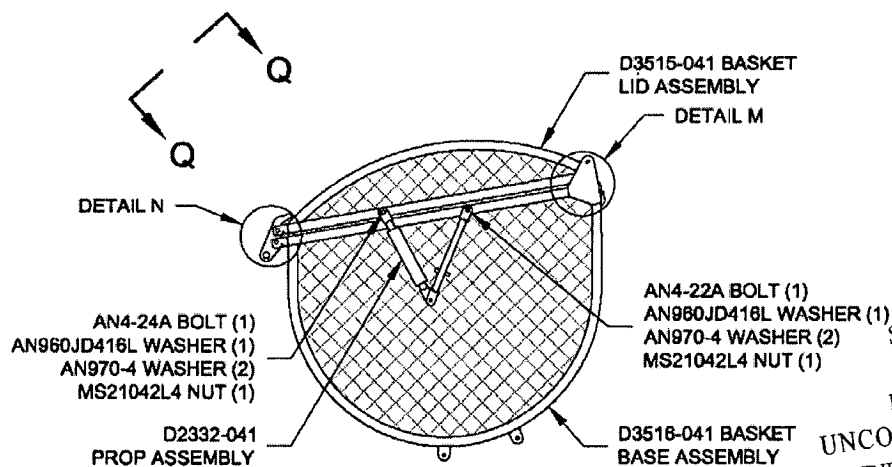
NOTE: Date & initial all entries

4.0 REPLACEMENT PARTS

Figures 4 and 5 list components of the Dart **Heli-Utility-Basket™** which can be replaced if required. Their part numbers are included for reference only, and are normally included with the D3515-041 Basket Lid Assembly or the D3516-041 Basket Base Assembly.



**D119-756-041
HELI-UTILITY-BASKET**



**VIEW C-C:
PROP ARM DETAIL**

**Figure 4 – Basket Replacement Parts
(D119-756-041 Heli-Utility-Basket™)**

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Revision: **C**

Date: 06.10.23

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WORK ORDER
NO. **37594**

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-756 REV. C &
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-756 REV. 0

REF. TCCA STC SH06-39

REF. FAA STC SR02364NY

ON THE D119-756-041 HELI-UTILITY-BASKET AT CHG 002 OR LATER, THE FORWARD AND AFT ENDS OF THE D3516-041 BASKET BASE ASSEMBLY HAVE BEEN UPGRADED WITH HOOPS AND FITTED WITH D3757-1 BLANKING PLATES. THE D3757-1 BLANKING PLATES MUST REMAIN INSTALLED OVER THE OPENINGS AT THE FORWARD AND AFT ENDS OF THE BASKET. REFER TO FIGURE 1 ON SHEET 2 OF THIS SERVICE INSTRUCTION.

THE PARTS LIST ON PAGE 14 OF IIN-D119-756 REV. C AND ON PAGES 41 AND 43 OF ICA-D119-756 REV. 0. SHOULD BE UPDATED AS FOLLOWS:

QTY -041	PART NUMBER	DESCRIPTION
X	D119-756-041	HELI-UTILITY-BASKET™
2	D3757-1	BLANKING PLATE
6	AN3-10A	BOLT
12	AN960JD10	WASHER
6	MS21042L3	NUT (OR MS21042-3)

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TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37594
4 08.02.22

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: _____
D. SHEPHERD (DE # 02)

DATE: 08.02.22
CERT. NO.: SH06-39
ISSUE NO.: 1

A	NEW ISSUE	MB	08.02.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9403	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASS'Y CHANGE	NTS
DATE	08.02.22	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

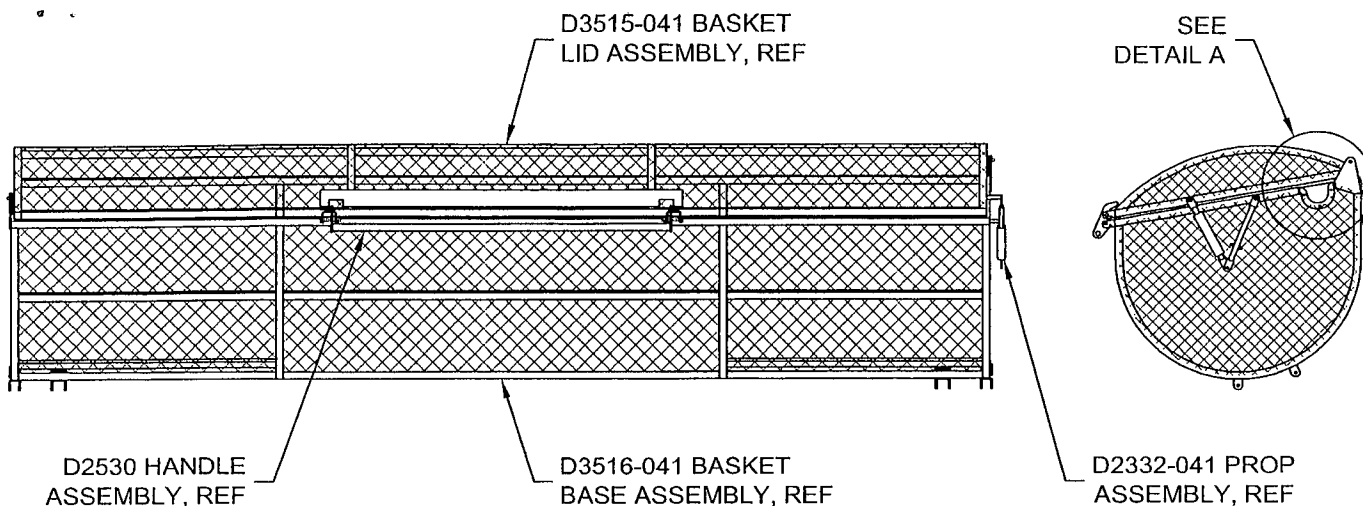
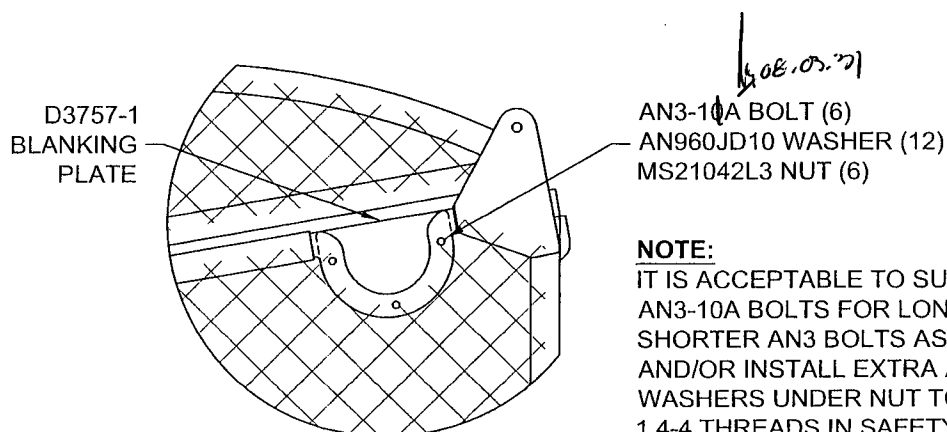


FIGURE 1 - D119-756-041 HELI-UTILITY-BASKET



DETAIL A - HOOP
SCALE 4X
TYP, BOTH ENDS

NOTE:
IT IS ACCEPTABLE TO SUBSTITUTE THE AN3-10A BOLTS FOR LONGER OR SHORTER AN3 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD10 WASHERS UNDER NUT TO ENSURE 1.4-4 THREADS IN SAFETY.

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37594

PRELIMINARY ISSUE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: _____
D. SHEPHERD (DE # 02)

DATE: 08.02.22
CERT. NO.: SH06-39
ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9403	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASS'Y CHANGE	NTS
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-756 REV. C &
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-756 REV. 0

REF. TCCA STC SH06-39

REF. FAA STC SR02364NY

REF. EASA STC EASA.IM.R.S.01289

ON THE D119-756-041 HELI-UTILITY-BASKET AT CHG 002 OR LATER, THE FORWARD AND AFT ENDS OF THE D3516-041 BASKET BASE ASSEMBLY HAVE BEEN UPGRADED WITH HOOPS AND FITTED WITH D3757-1 BLANKING PLATES. THE D3757-1 BLANKING PLATES MAY BE REMOVED TO ALLOW THE OPERATOR TO RUN A CABLE OUT OF THE BASKET TO THE AIRCRAFT. IT IS THE RESPONSIBILITY OF THE OPERATOR TO ENSURE THAT THE CABLE IS PROPERLY SECURED FOR FLIGHT. REFER TO FIGURE 1 ON SHEET 2 OF THIS SERVICE INSTRUCTION.

THE PARTS LIST ON PAGE 14 OF IIN-D119-756 REV. C AND ON PAGES 41 AND 43 OF ICA-D119-756 REV. 0. SHOULD BE UPDATED AS FOLLOWS:

QTY -041	PART NUMBER	DESCRIPTION
X	D119-756-041	HELI-UTILITY-BASKET™
2	D3757-1	BLANKING PLATE
6	AN3-10A	BOLT
12	AN960JD10	WASHER
6	MS21042L3	NUT (OR MS21042-3)

37591
37592
37593
37594
37595
37596 ✓

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 08.02.22
CERT. NO.: SH06-39
ISSUE NO.: 1

A	NEW ISSUE	MB	08.02.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. A
CHECKED		DSI 9405	SHEET 1 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET BASE ASS'Y CHANGE	NTS
DE APPR.		COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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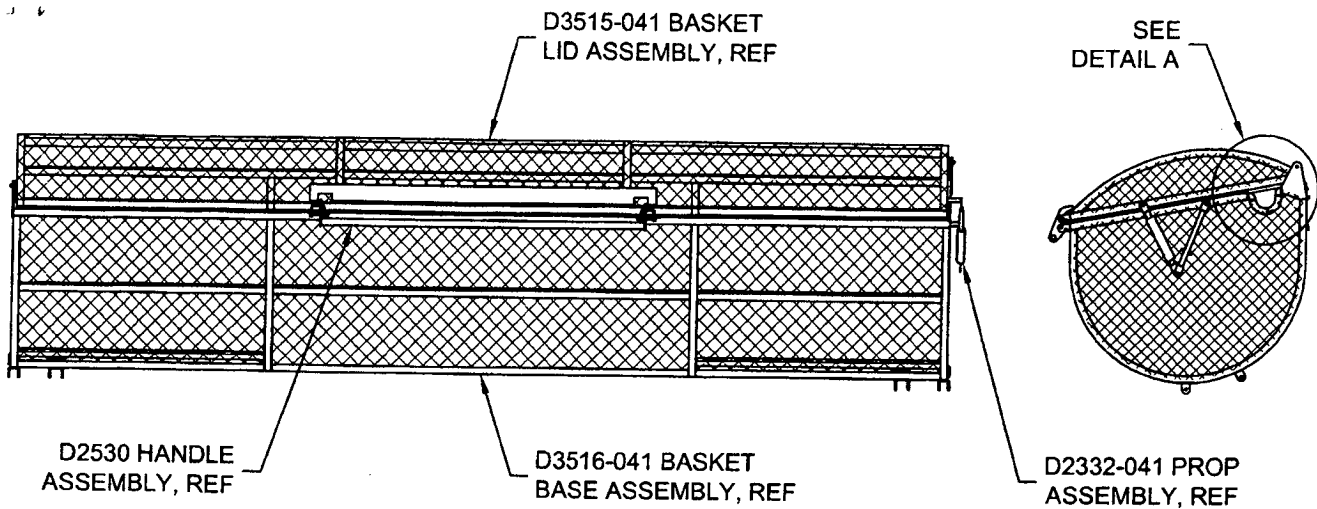
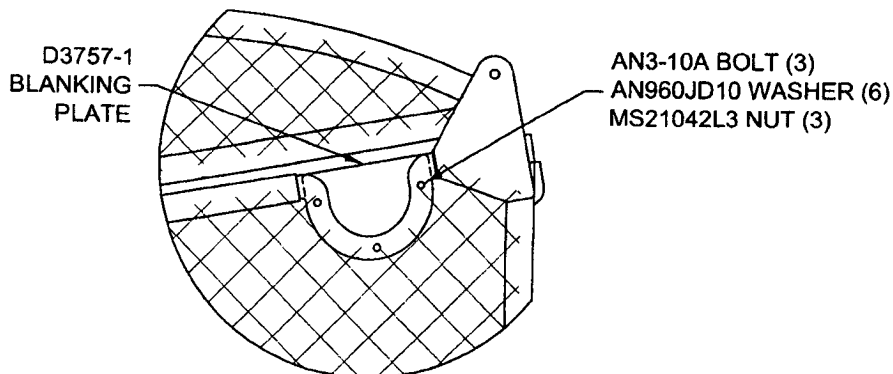


FIGURE 1 - D119-756-041 HELI-UTILITY-BASKET



DETAIL A - HOOP
SCALE 4X
TYP, BOTH ENDS

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 08.02.22
CERT. NO.: SH06-39
ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9405	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASS'Y CHANGE	NTS
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 Job Number : 37594
 Estimate Number : 12452
 P.O. Number :
 This Issue : 2/25/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D119756041
 First Issue : // Type : LARGE FAB ASSY Drawing Number : IIN PG11-12
 Previous Run : 37593 Drawing Revision : C
 Material :
 Due Date : 3/30/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev. A New Issue 06-06-14 JLM
 Est Rev. B 06.07.26 dwg revB, picklist EC
 est rev C revC dwg 07.04.09 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD119-756-041 CHG 001

08 03 25

2.0 37594A BASKET LID ASS'Y (A119)



Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT

3.0 37594B BASKET BASE ASS'Y (A119) PRELIMINARY



Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT

4.0 D2022101 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: _____

5.0 D2258220 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: _____

6.0 D2332041 Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: _____

REFER TO ONLY

Date: Monday, 2/25/2008 11:18:03 AM
 User: Kim Johnston

Process Sheet

14

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASS'Y (A119)
Job Number : 37594A	
Estimate Number : 12445	
P.O. Number :	Part Number : D3515041
This Issue : 2/25/2008 S.O. No. :	Drawing Number : D3515 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 37593A	Material :
Written By :	Due Date : 3/30/2008 Qty: 1 Um: Each
Checked & Approved By : <u>08 02 26</u>	
Comment : EST rev. A 06.06.05 Preliminary EC	
est B 07.04.09 revA dwg EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D22321	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B35684 ✓

PD 08-03-18

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Basket Hoop

Batch: B36860 ✓

PD 08-03-18

3.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: B36920 ✓

PD 08-03-18

4.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: B35585 ✓

PD 08-03-27

5.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: B36481 ✓

PD 08-03-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:18:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 37594A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)
AISI 304 SQ Tube.75x.75x.065W
Batch: ml07315 ✓

JS 08/03/18
FC 08 03 17

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Cut rib D3515-1 (2) as per dwg D3516

2-Cut rib D3515-3 (2) as per dwg D3516

3-Cut rib D3515-5 (6) as per dwg D3516

4-Cut rib D3515-7 (3) as per dwg D3516

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

JS 08/03/18

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Weld assembly as per dwg D3515

PD 08-03-18

9.0

QC5/9

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/03/20

10.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)
Expanded Metal Flat Stainless steel
Batch: M107316

JS 08/03/27

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

JS

JS

JS

JS 08/03/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:18:03 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 37594A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

JD

08-03-27

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JD

08-03-27

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 107005

JK

08-03-28

①

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-A

08/03/28

(1X)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3515 and QSI 005 4.4 and spray paint as per dwg

wing walk:

M 107385

black spray paint:

M 107230

M-A

08/03/28

(1X)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 08/03/31

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 08/03/31

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

JA 08.03.31

Job Completion



U 08-03-31

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

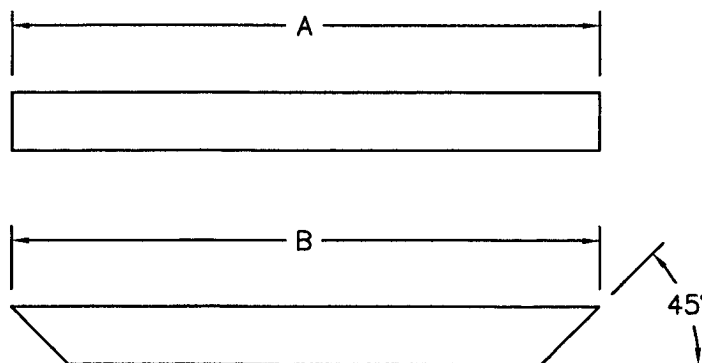
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

RELEASED06.11.17 *[Signature]***PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH	LENGTH	DESCRIPTION
		A	B	
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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NO. **37594A**

D3515-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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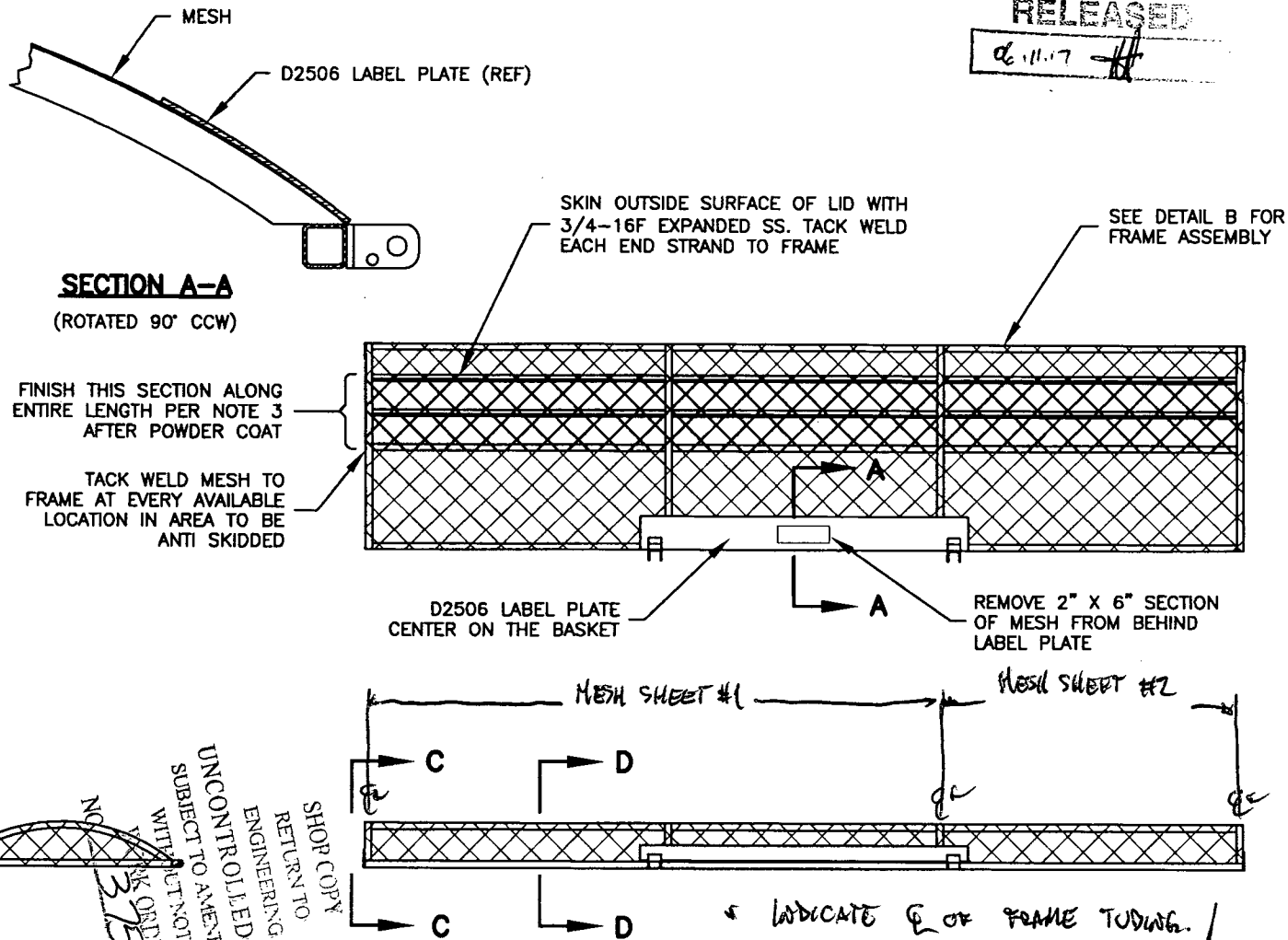
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3515
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)
		REV. A
		SHEET 2 OF 4
		SCALE 1:20

RELEASED

06.11.17



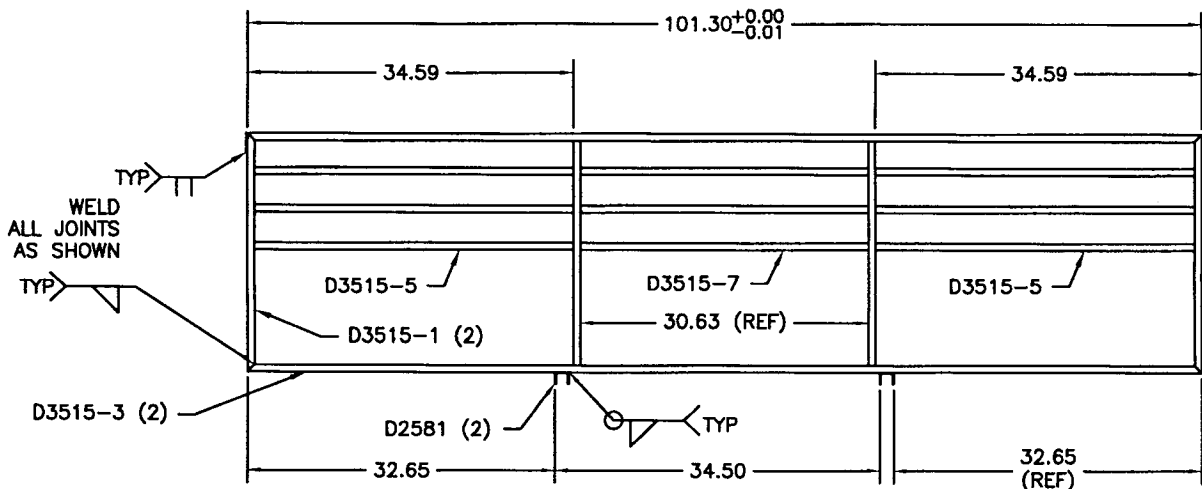
D3515-041 BASKET LID ASSEMBLY

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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NO. 375944

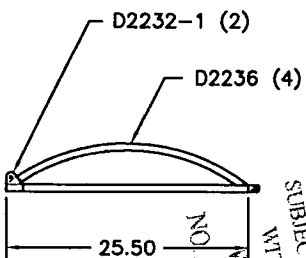
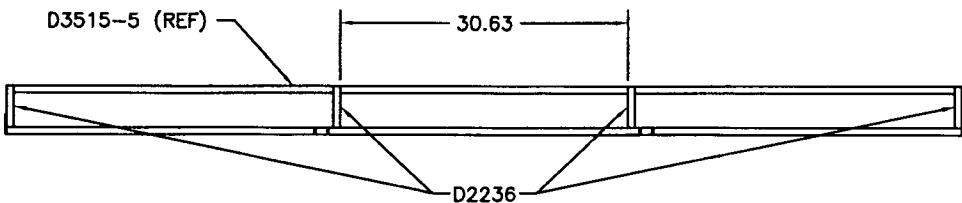
DART

DESIGN	APPROVED	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	D3515
DATE	06.05.05	TITLE	BASKET LID ASSEMBLY (A119)
		REV. A	SHEET 3 OF 4
		SCALE	1:20



DETAIL B

FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



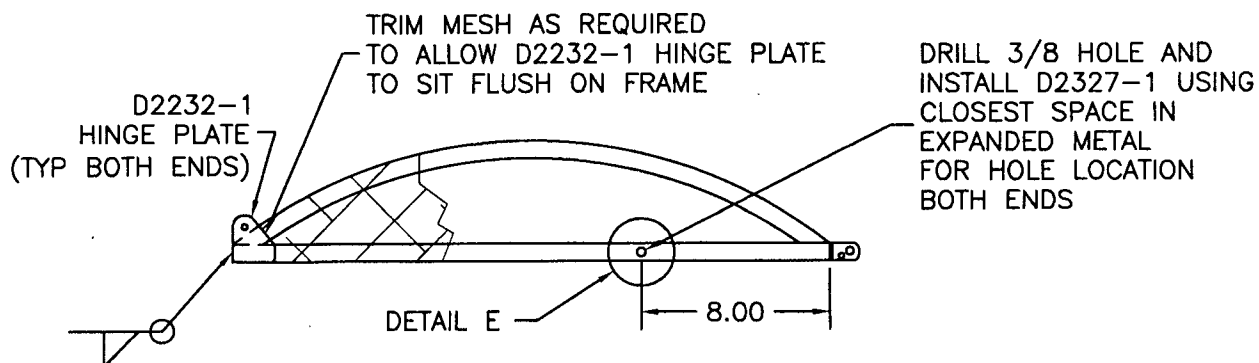
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375844A

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06.11.07

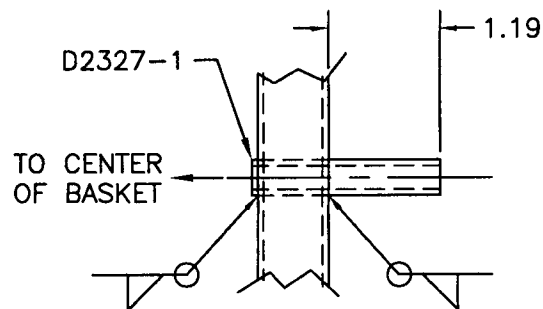


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8

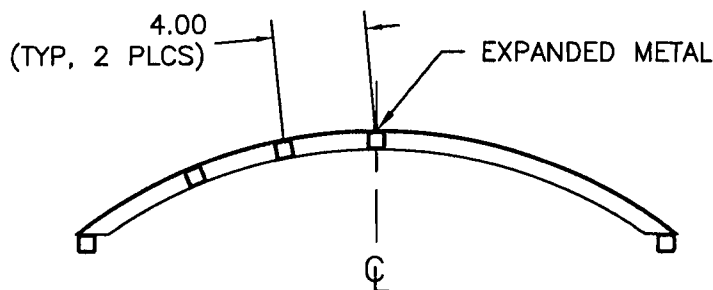


SECTION C-C SIMILAR BOTH END RIBS

RELEASED
06-11-17 *[Signature]*



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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WORK ORDER
NO. 37594A

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14

Date: Monday, 2/25/2008 11:18:13 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET BASE ASS'Y (A119) PRELIMINARY
 Job Number : 37594B
 Estimate Number : 12431
 P.O. Number :
 This Issue : 2/25/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3516041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3516 REV C PREMIL
 Previous Run : 37593B Drawing Revision : C
 Material :
 Due Date : 3/30/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : EST rev. A 06.05.31 Preliminary EC
 EST rev. b 06.07.27 updated EC
 Est Rev:C 08-02-25 ECN 1138P DD verified by:



Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

Batch: B3410 ✓

PD 08-03-18

2.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: B36481 ✓

PD 08-03-18

3.0 D351611 CLEVIS



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

CLEVIS

batch: B31626 ✓

PD 08-03-18

4.0 D351613 CLEVIS



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

* CLEVIS

batch: B30911 → 3 ✓

batch: B31801 → 1 *

PD 08-03-18

5.0 D23273 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: B36479 ✓

PD 08-03-18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:18:14 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119) PRELIMINARY

Job Number: 37594B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B36846 ✓

PD 08-03-13

7.0

D31661

Basket Hoop



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIB

Batch: B37572 ✓

PD 08-03-13

8.0

D37251

HOOP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

* HOOP

batch B37626

PD 08-03-13

9.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 53.1825 f(s)/Unit Total : 53.1825 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: M107315 ✓

JH 08/03/18

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3516-1 as per dwg D3516

2-Cut rib D3516-3 as per dwg D3516

3-Cut rib D3516-5 as per dwg D3516

4-Cut rib D3516-7 as per dwg D3516

5- Cut rib D3516-15 as per dwg D3516

6-Cut rib D3516-9 from D3166-1 (4)

JH 08/03/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:18:14 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119) PRELIMINARY

Job Number: 37594B

Part Number: D3516041

Job Number:



Seq. #: Machine Or Operation: Description:

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3516

PD 08-03-20

12.0 ~~QC 5/9~~ INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

A 08/03/20

13.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 60.0000 sf(s)/Unit Total: 60.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: M107316

FC 08 03 27

14.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

FC

2-Cut expanded metal for base ends as per dwg D3516

FC

3-Weld expanded metal to base as per dwg D3516

FC

08 03 27

15.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

B 08-03-27

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

B 08-03-27

PD 08-03-27

17.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

B 08-03-28

18.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 08/03/28 (1X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:18:14 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119) PRELIMINARY

Job Number: 37594B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 08/03/31

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.03.31

Job Completion



U 08.03.31

POSITIVE RECALL

EFFECTIVE 08.03.31 AUTH [Signature]

RELEASED [Signature] DATE 08.03.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

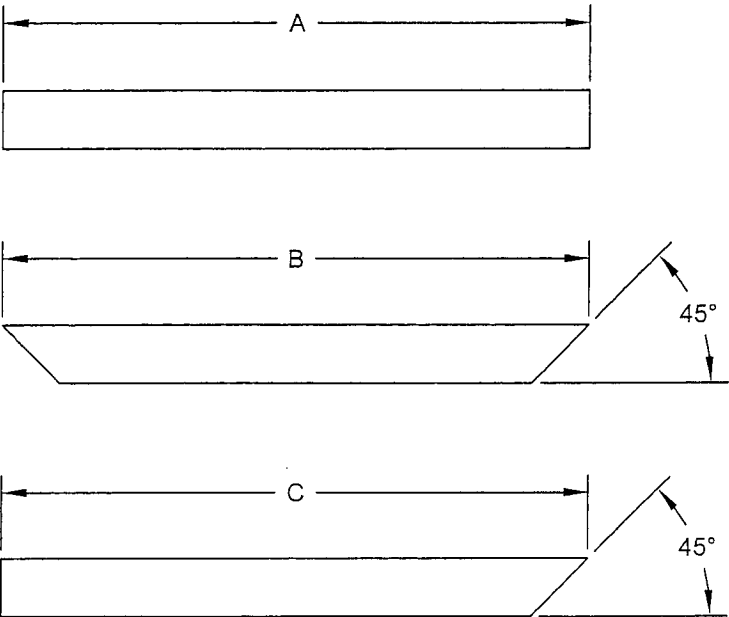
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	LENGTH C	DESCRIPTION
D2232-3 ✓	2	N/A	N/A	N/A	HINGE PLATE
D2327-3 ✓	2	N/A	N/A	N/A	BUSHING
D2581 ✓	2	N/A	N/A	N/A	MOUNTING BRAKET
D3442-1 ✓	2	N/A	N/A	N/A	SHIM
D3516-1 ✓	2	—	102.00	—	RIB
D3516-3 ✓	2	—	—	2.70	RIB
D3516-5 ✓	8	26.75	—	—	RIB
D3516-7 ✓	3	45.50	—	—	RIB
D3516-9 ✓	4	N/A	N/A	N/A	RIB (MAKE FROM D2235-3)
D3516-11 ✓	6	N/A	N/A	N/A	CLEVIS
D3516-13 ✓	4	N/A	N/A	N/A	CLEVIS
D3516-15 ✓	2	—	—	19.32	RIB
D3725-1 ✓	2	N/A	N/A	N/A	HOOP



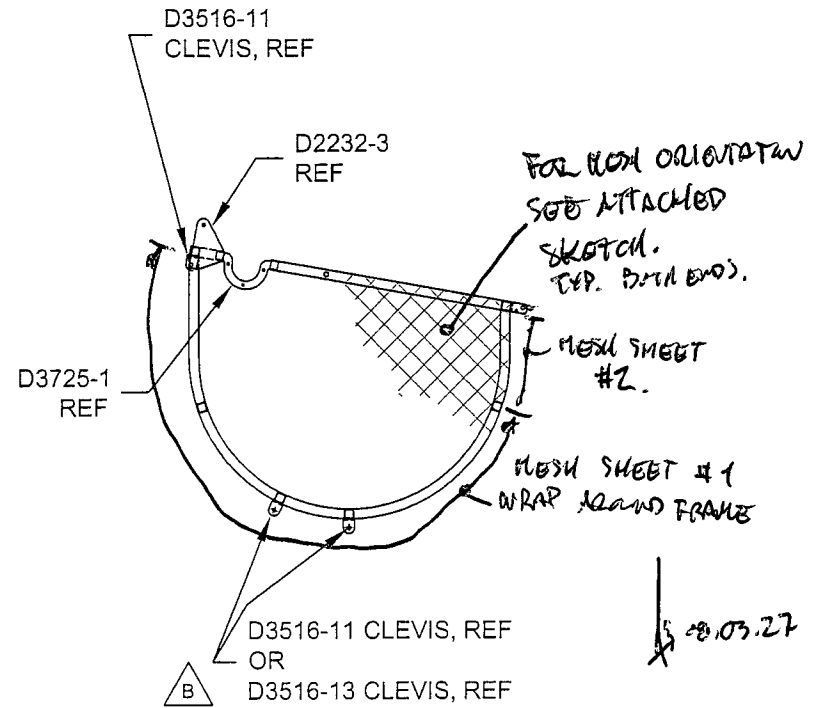
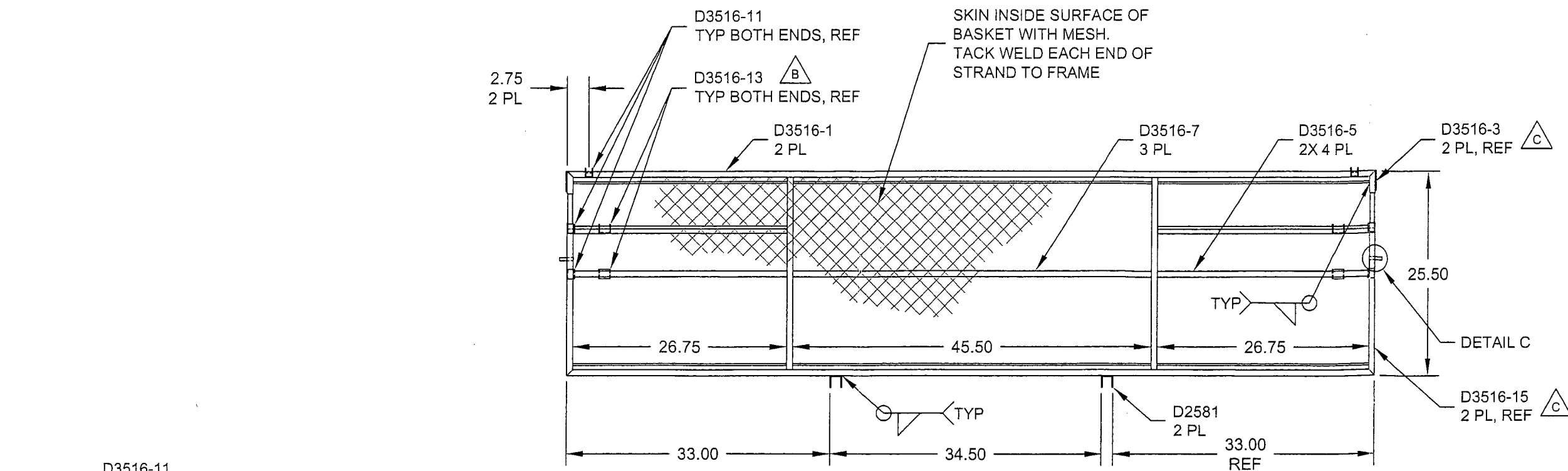
D3615-041 BASKET BASE ASSEMBLY NOTES:

- 1) MATERIAL:
FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL
(REF. DART SPEC. M304TS0.750W.065)
MESH - 3/4-16F EXPANDED STAINLESS STEEL
(REF. DART SPEC. M304EX0.75-16F)
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 75 lbs
- 8) WELDING: PER DART QSI 004

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NO. 37594B

PRELIMINARY ISSUE

C	ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST	MB	08.02.20
B	ADD QTY.(4) D3516-13; QTY.(8) D3516-11 WAS QTY.91) SEE TR-D119-756-1 REV. A	MB	06.07.25
A	NEW ISSUE	MB	06.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY	NTS
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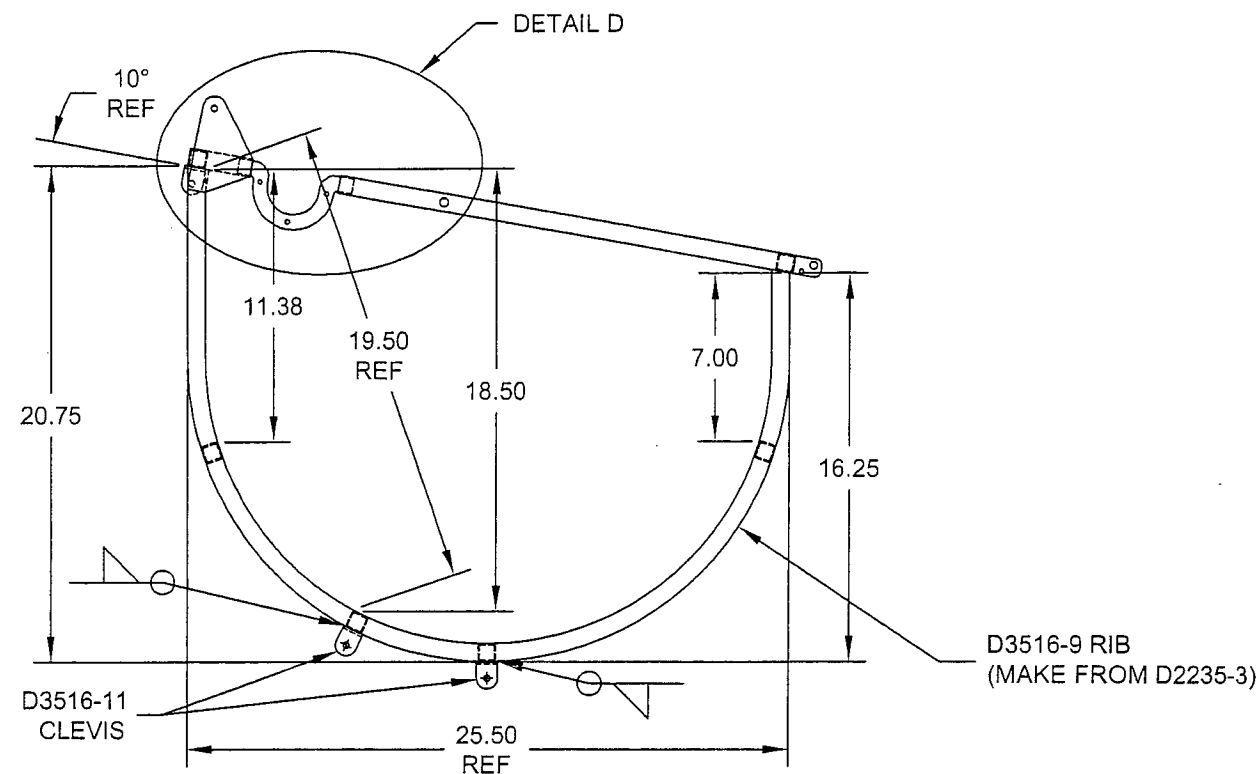


D3516-041 BASKET BASE ASSEMBLY

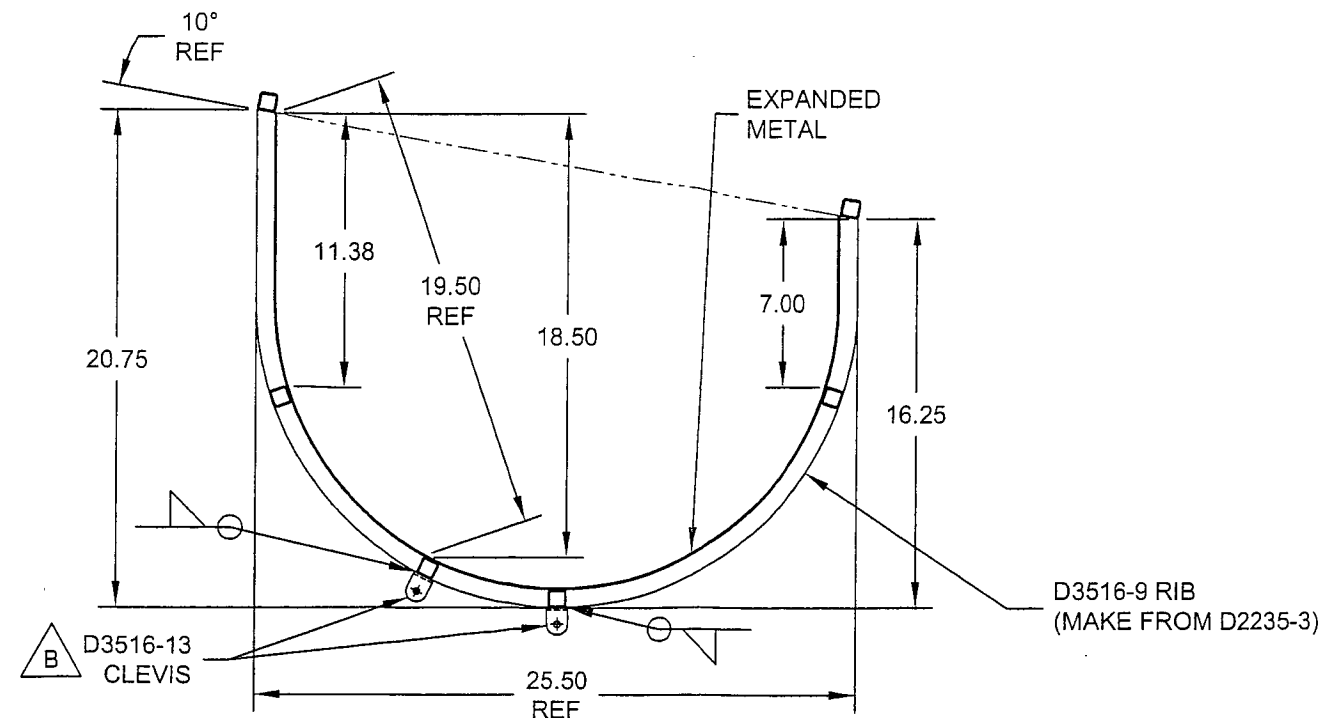
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WORK ORDER
NO. 37594B

PRELIMINARY ISSUE
08.02.22

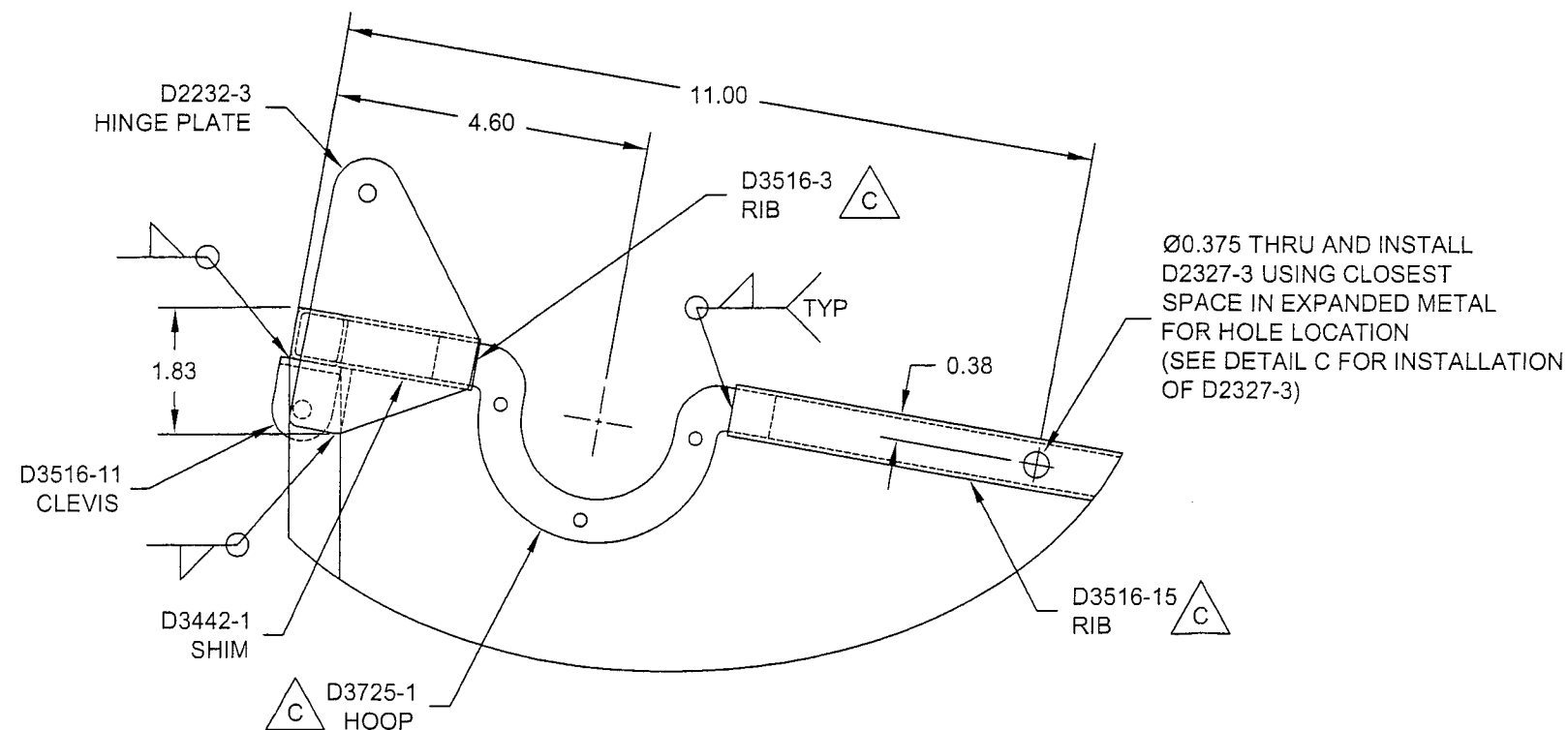
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MFG. APPR.		D3516	SHEET 2 OF 4
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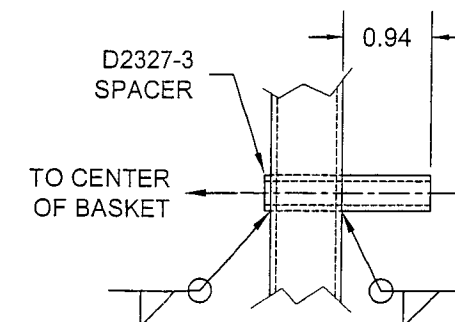
SECTION A-A: END RIB DETAIL
TYP BOTH ENDS



SECTION B-B: CENTER RIB DETAIL
2 PL



DETAIL D: HOOP & HINGE PLATE DETAIL
FRONT SHOWN, BACK SIMILAR
SCALE 3X

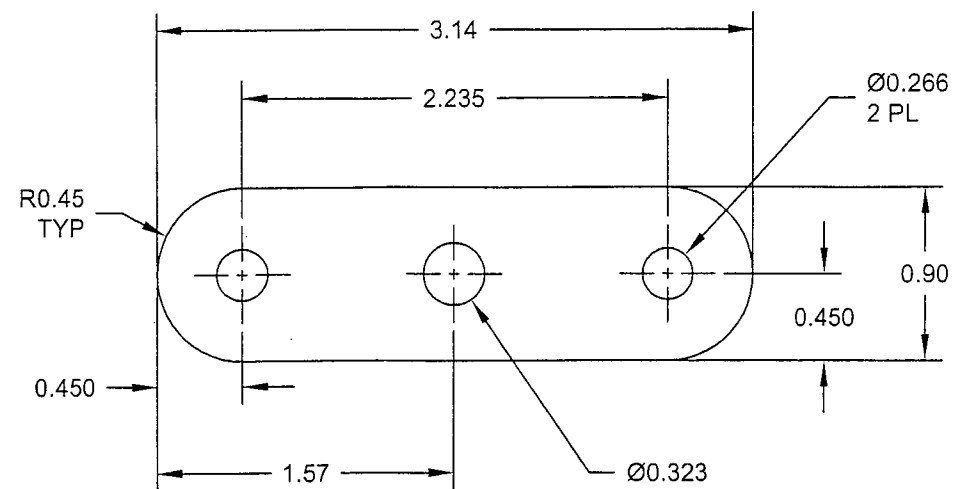


DETAIL C: SPACER INSTALLATION
SCALE 4X

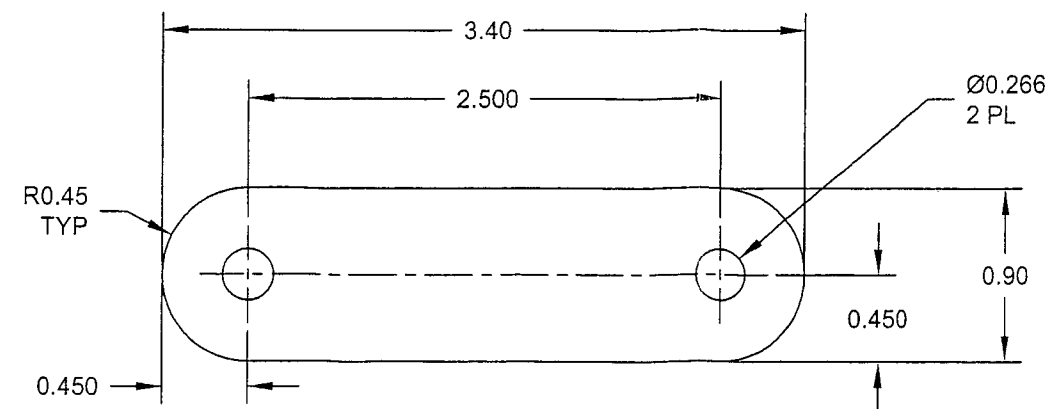
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PRELIMINARY ISSUE 08.02.20

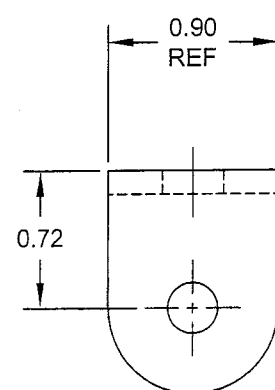
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MFG. APPR.		D3516	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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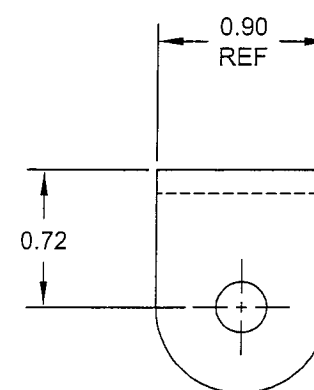
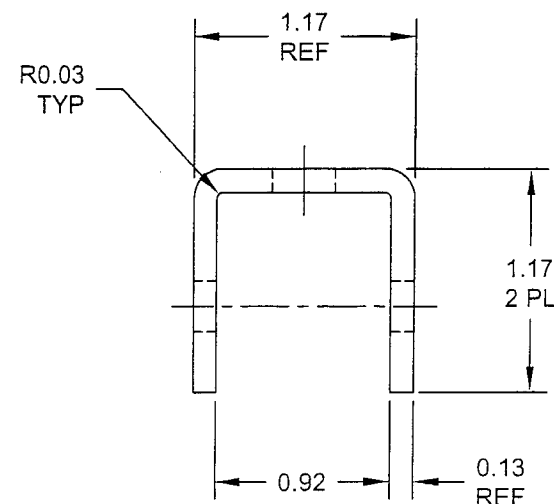
1 D3516-11F CLEVIS FLAT PATTERN



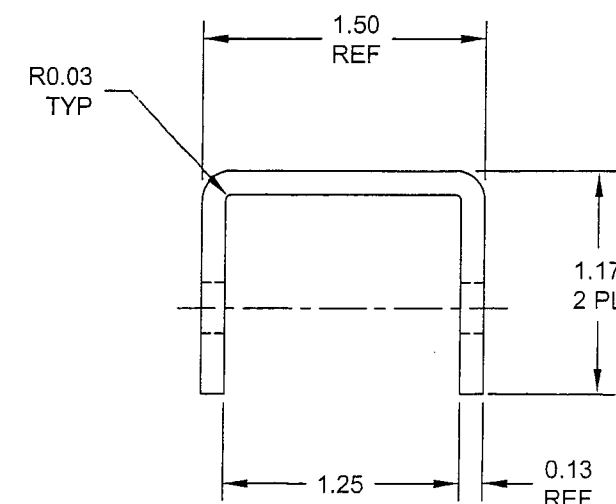
1 D3516-13F CLEVIS FLAT PATTERN



D3516-11 CLEVIS BENDING DETAIL
(MAKE FROM D3516-11F)



D3516-13 CLEVIS BENDING DETAIL
(MAKE FROM D3516-13F)



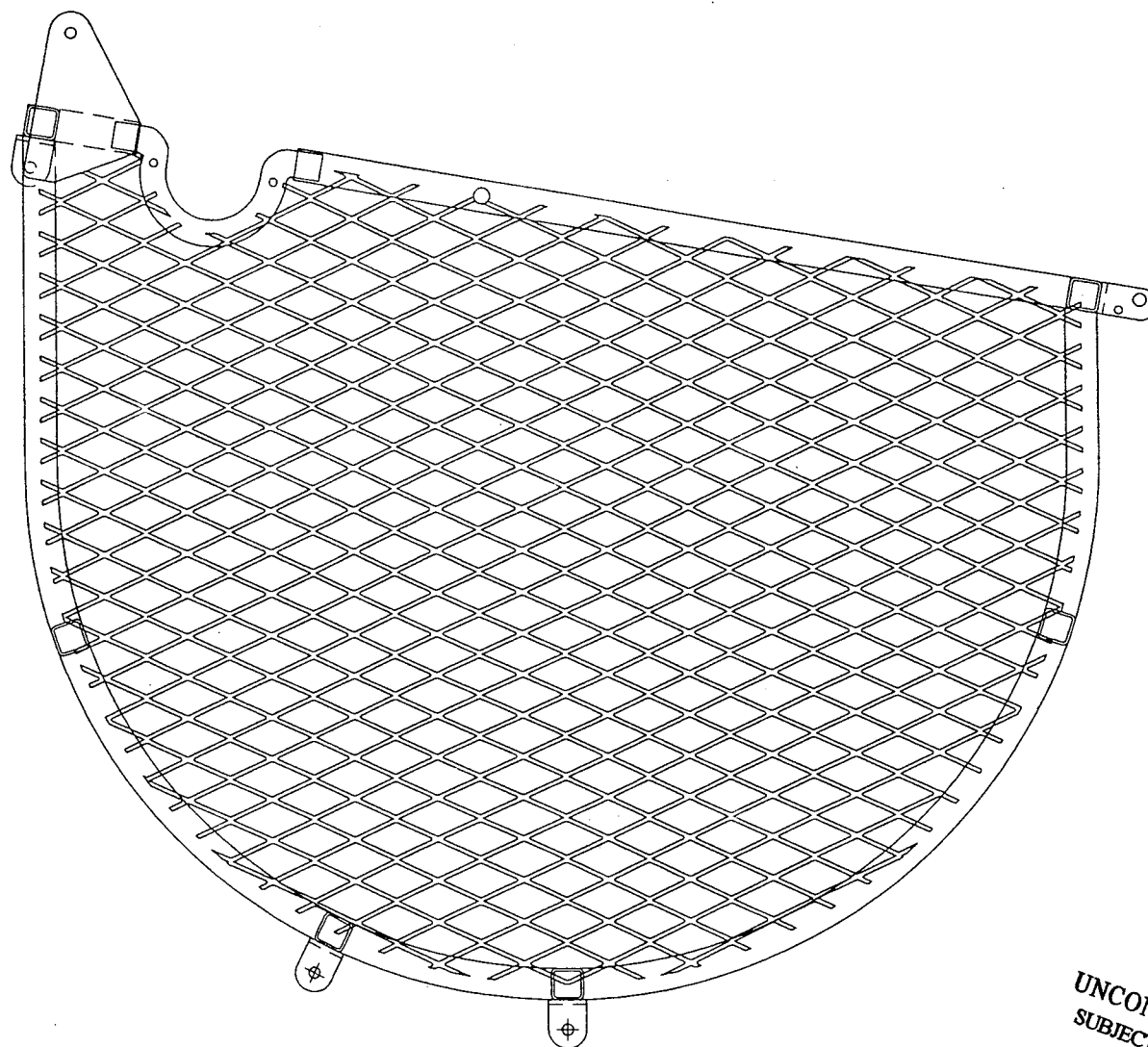
D3516-11/-13 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs
D3516-13 = 0.10 lbs

PRELIMINARY ISSUE

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MFG. APPR.		D3516	SHEET 4 OF 4
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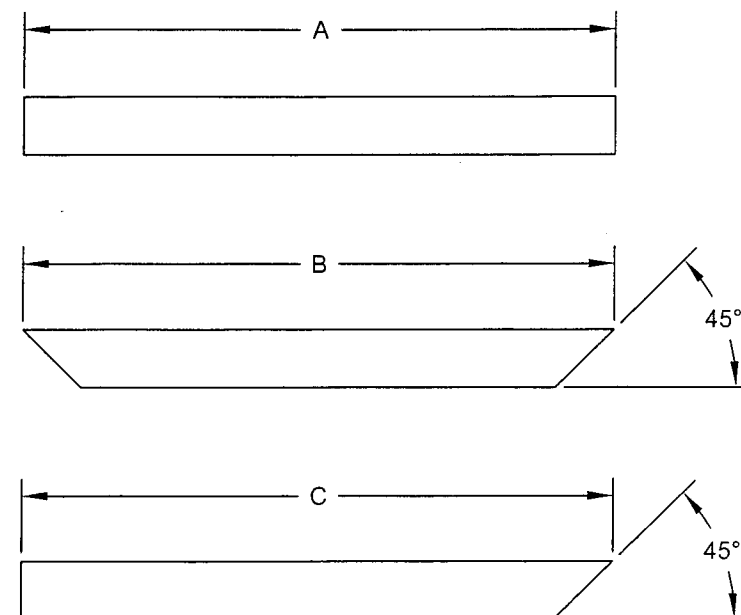


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NO. 373940

08.03.27

PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	LENGTH C	DESCRIPTION
D2232-3	2	N/A	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	N/A	BUSHING
D2581	2	N/A	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	N/A	SHIM
D3516-1	2	—	102.00	—	RIB
D3516-3	2	—	—	2.70	RIB
D3516-5	8	26.75	—	—	RIB
D3516-7	3	45.50	—	—	RIB
D3516-9	4	N/A	N/A	N/A	RIB (MAKE FROM D2235-3)
D3516-11	6	N/A	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	N/A	CLEVIS
D3516-15	2	—	—	19.32	RIB
D3725-1	2	N/A	N/A	N/A	HOOP

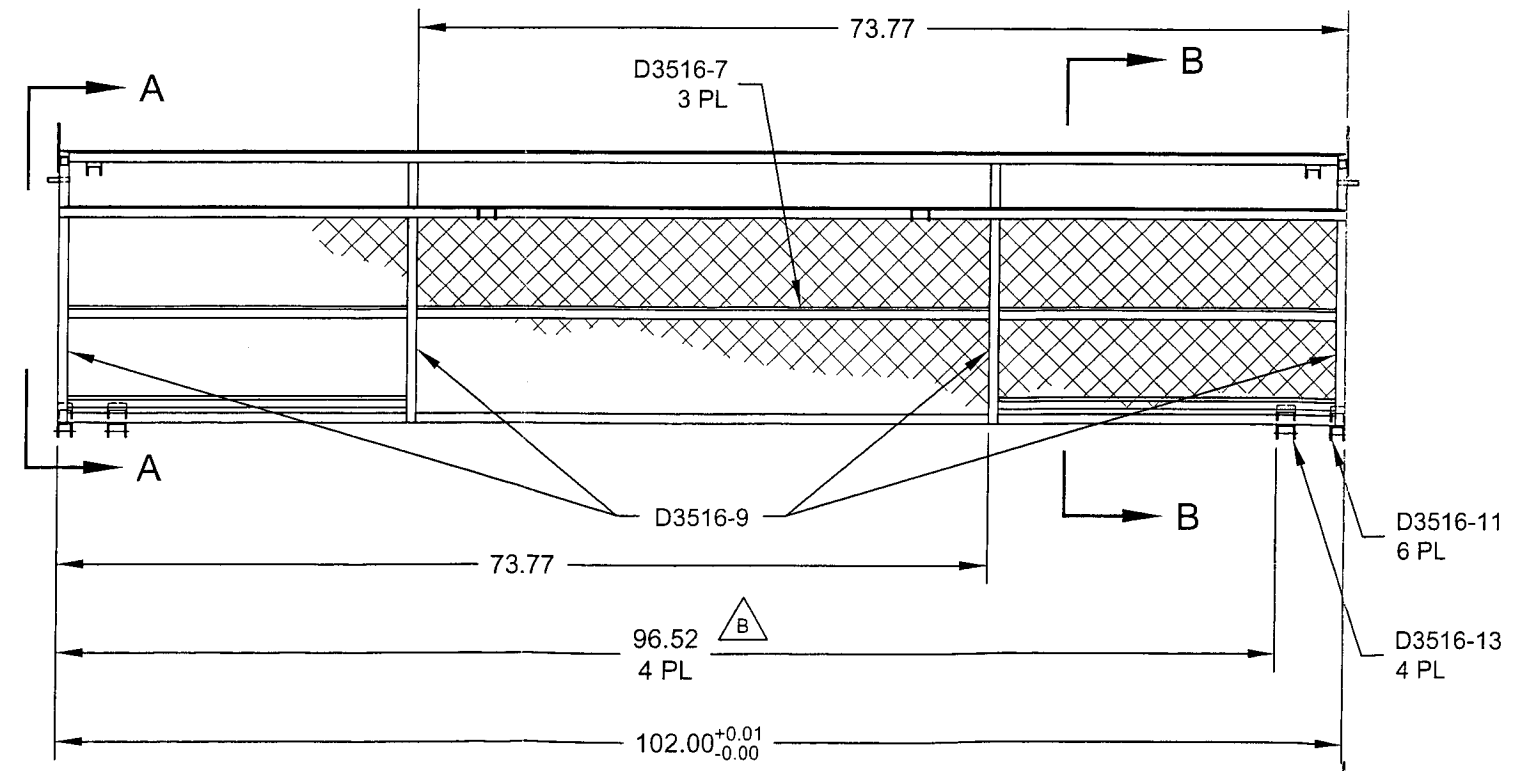
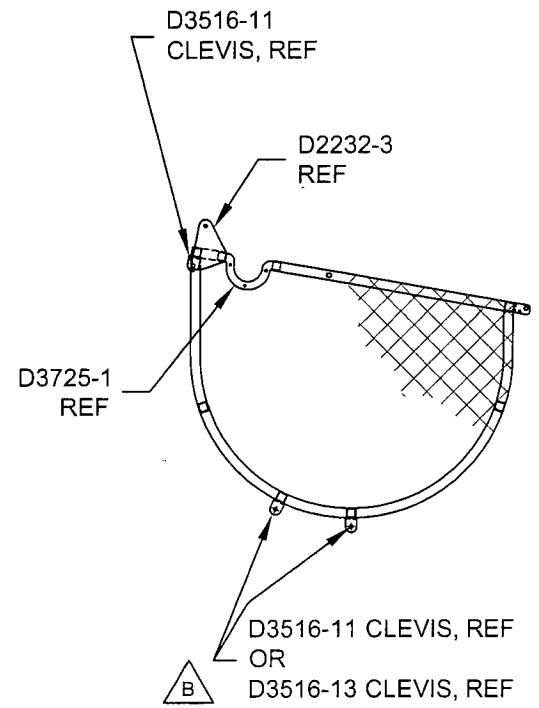
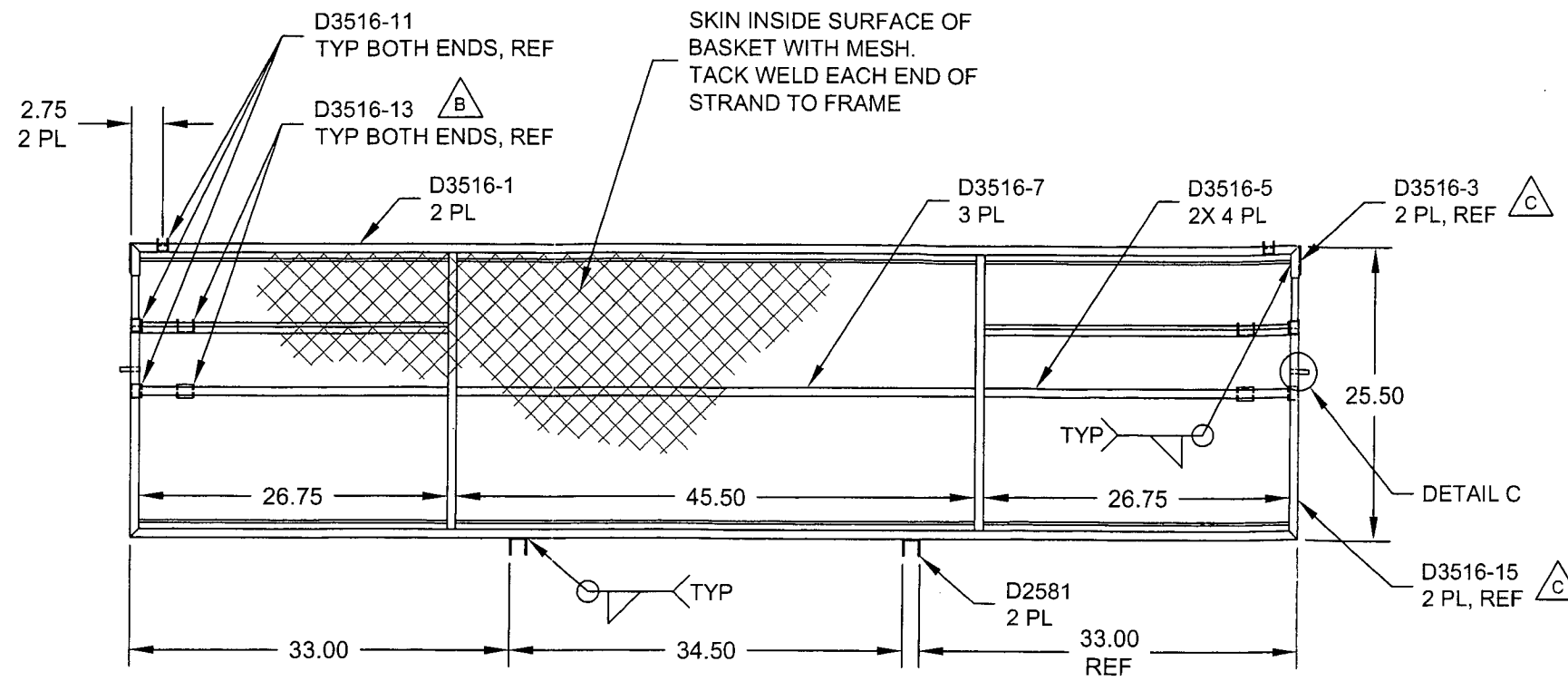


D3516-041 BASKET BASE ASSEMBLY NOTES:

- MATERIAL:
FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL
(REF. DART SPEC. M304TS0.750W.065)
MESH - 3/4-16F EXPANDED STAINLESS STEEL
(REF. DART SPEC. M304EX0.75-16F)
- FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: N/A
- WEIGHT: 75 lbs
- WELDING: PER DART QSI 004

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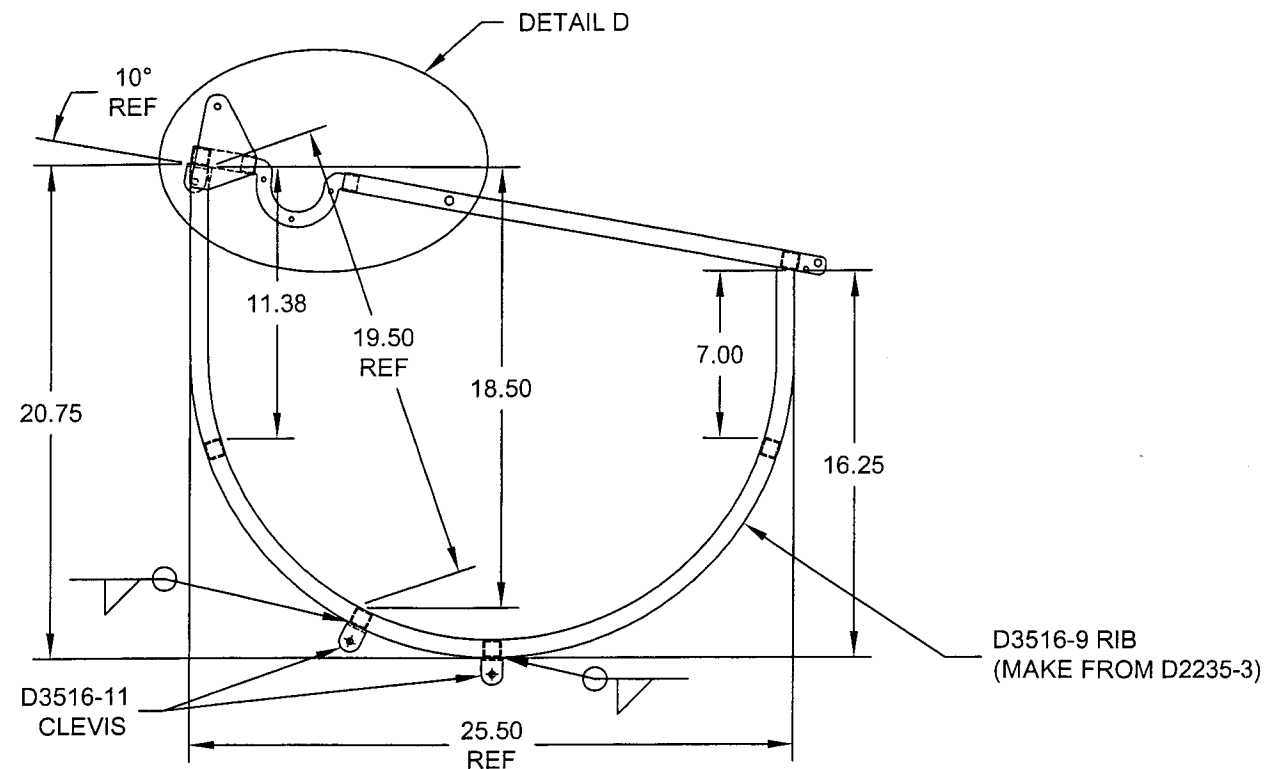
C	ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST	MB	08.02.20
B	ADD QTY.(4) D3516-13; QTY.(6) D3516-11 WAS QTY.(1) SEE TR-D119-756-1 REV. A	MB	06.07.25
A	NEW ISSUE	MB	06.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY	NTS
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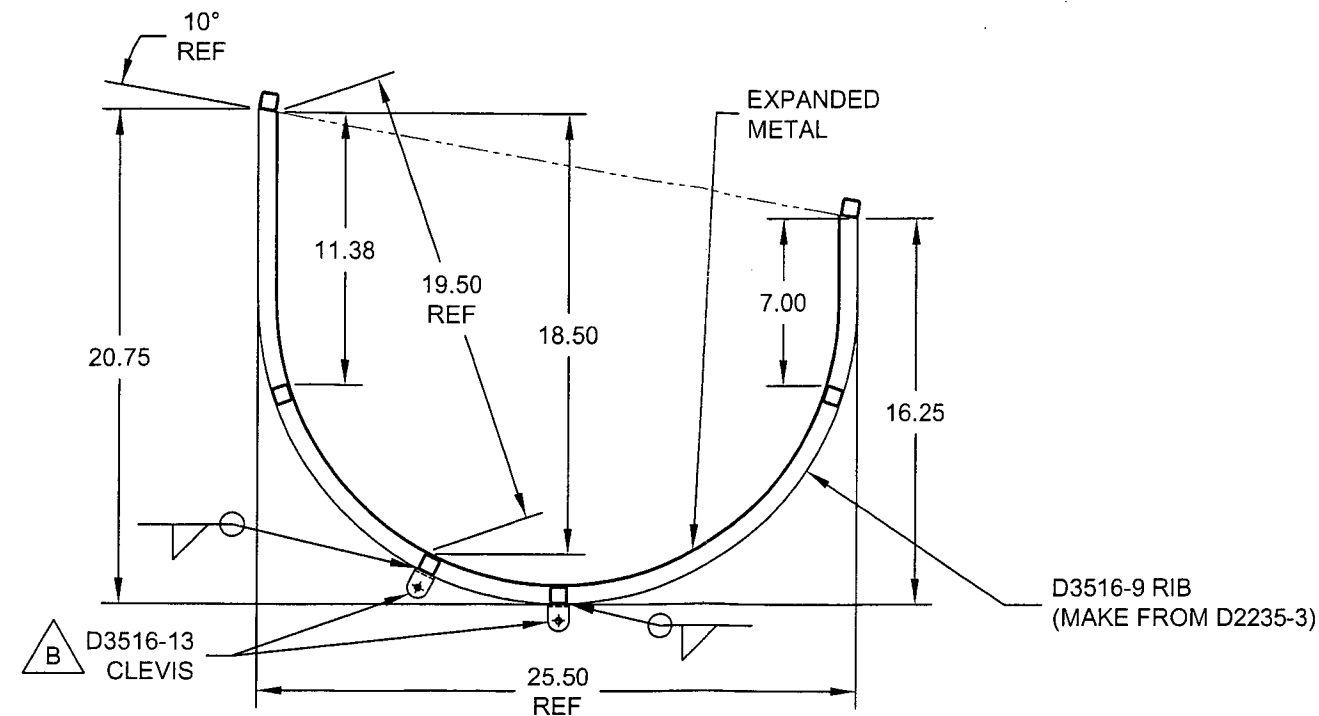
D3516-041 BASKET BASE ASSEMBLY

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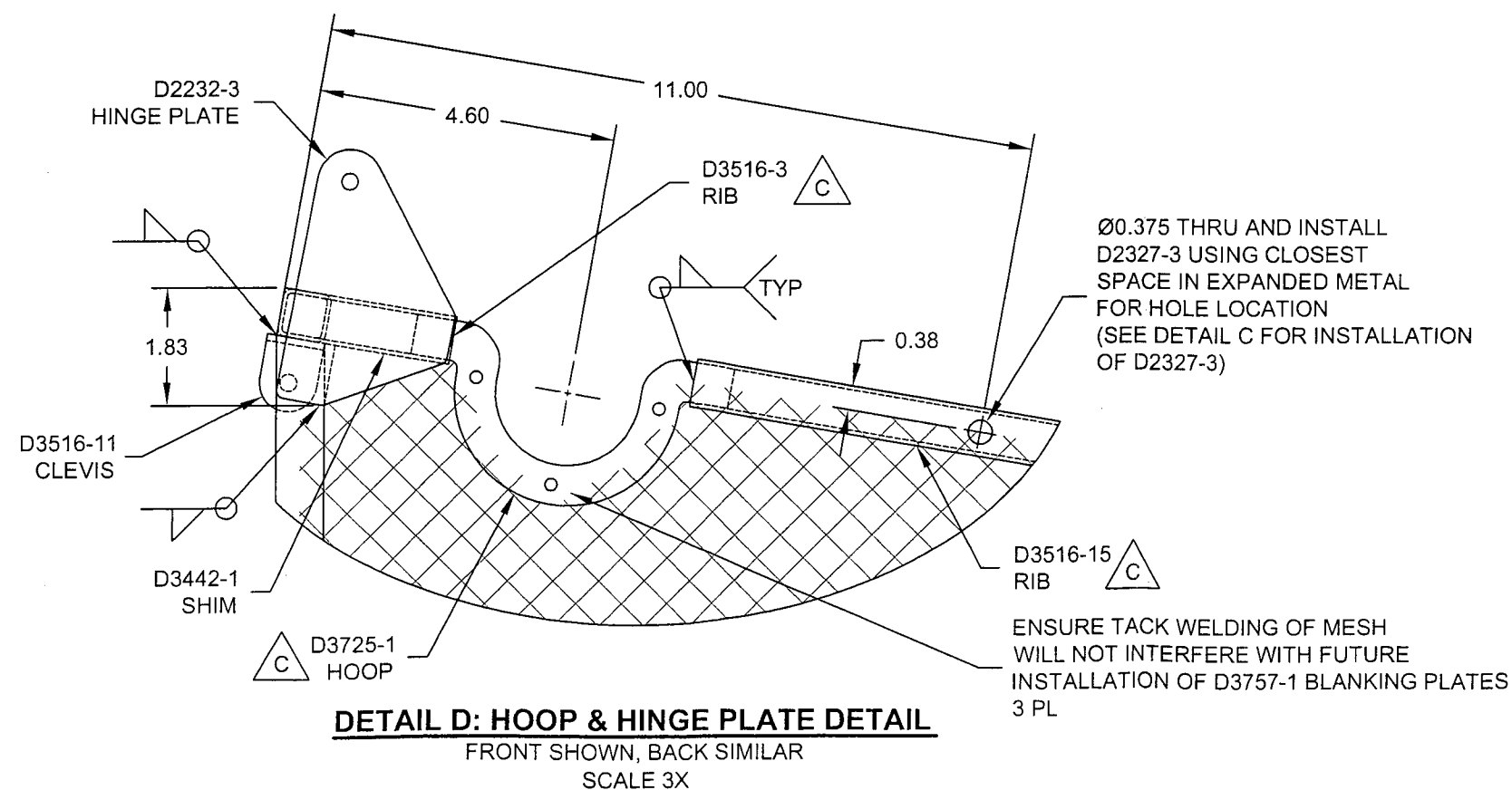
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 2 OF 4
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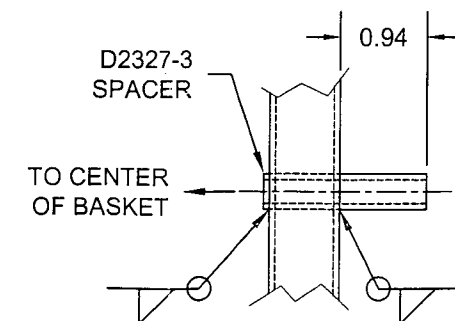
SECTION A-A: END RIB DETAIL
(MESH NOT SHOWN FOR CLARITY)
TYP BOTH ENDS



SECTION B-B: CENTER RIB DETAIL
2 PL

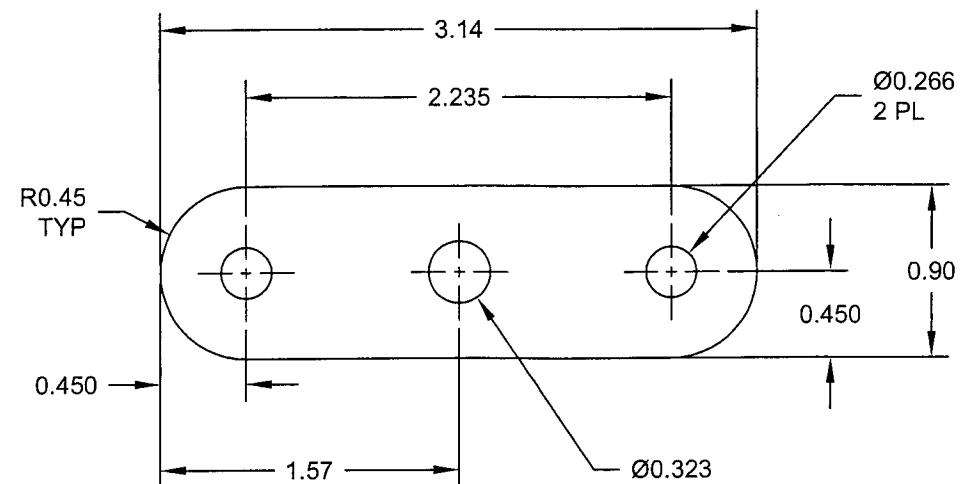


DETAIL D: HOOP & HINGE PLATE DETAIL
FRONT SHOWN, BACK SIMILAR
SCALE 3X

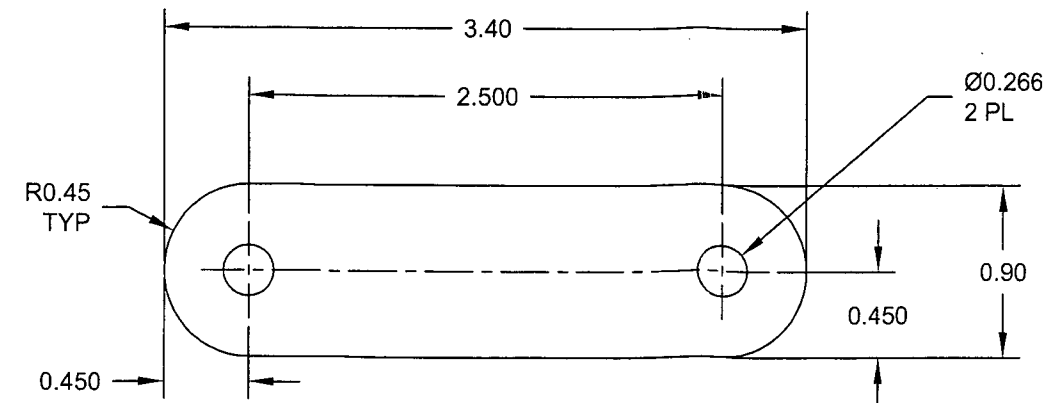


DETAIL C: SPACER INSTALLATION
SCALE 4X

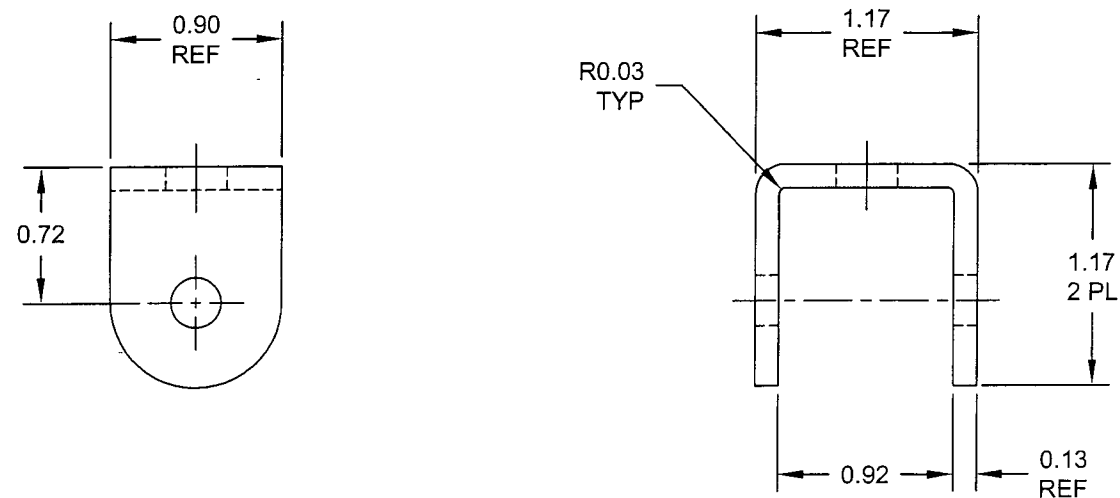
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CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 3 OF 4
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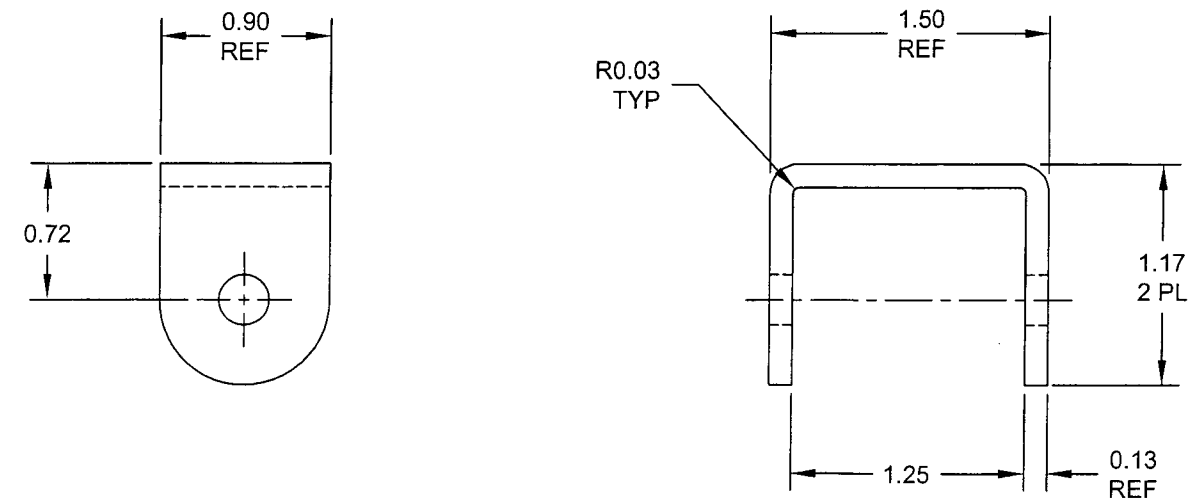
1 D3516-11F CLEVIS FLAT PATTERN



1 D3516-13F CLEVIS FLAT PATTERN







D3516-11 CLEVIS BENDING DETAIL
(MAKE FROM D3516-11F)



D3516-13 CLEVIS BENDING DETAIL
(MAKE FROM D3516-13F)

D3516-11/-13 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs
D3516-13 = 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 4 OF 4
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